

DUPLICATE

Dart Aerospace Ltd.

Date: Wednesday, 16/05/2007 8:42:32 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 28491 - 7 Estimate Number : 10377 P.O. Number : N/A This Issue : 16/05/2007 S.O. No. : N/A Prsht Rev. : NC First Issue : 12/09/2006 Type : PURCHASED PARTS Previous Run : 28490 Written By : _____ Checked & Approved By : _____ Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM	Drawing Name : AFT CROSSTUBE Part Number : D2890 Drawing Number : D2890 REV B Project Number : N/A Drawing Revision : B Material : N/A Due Date : 30/09/2006 Qty: 17 Um: Each
---	---

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6008180	Crosstube extrusion
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	22534

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
ACID ETCH & ALODINE

Material
Purchased
Approved.

N/A

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

Rebend
EL-7-5-17

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

2005-23

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/05/2007 8:42:32 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 28491

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

NIA

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

NIA

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: W/O 28596

70705-23

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1

2107105124

Job Completion



U 27 05-24

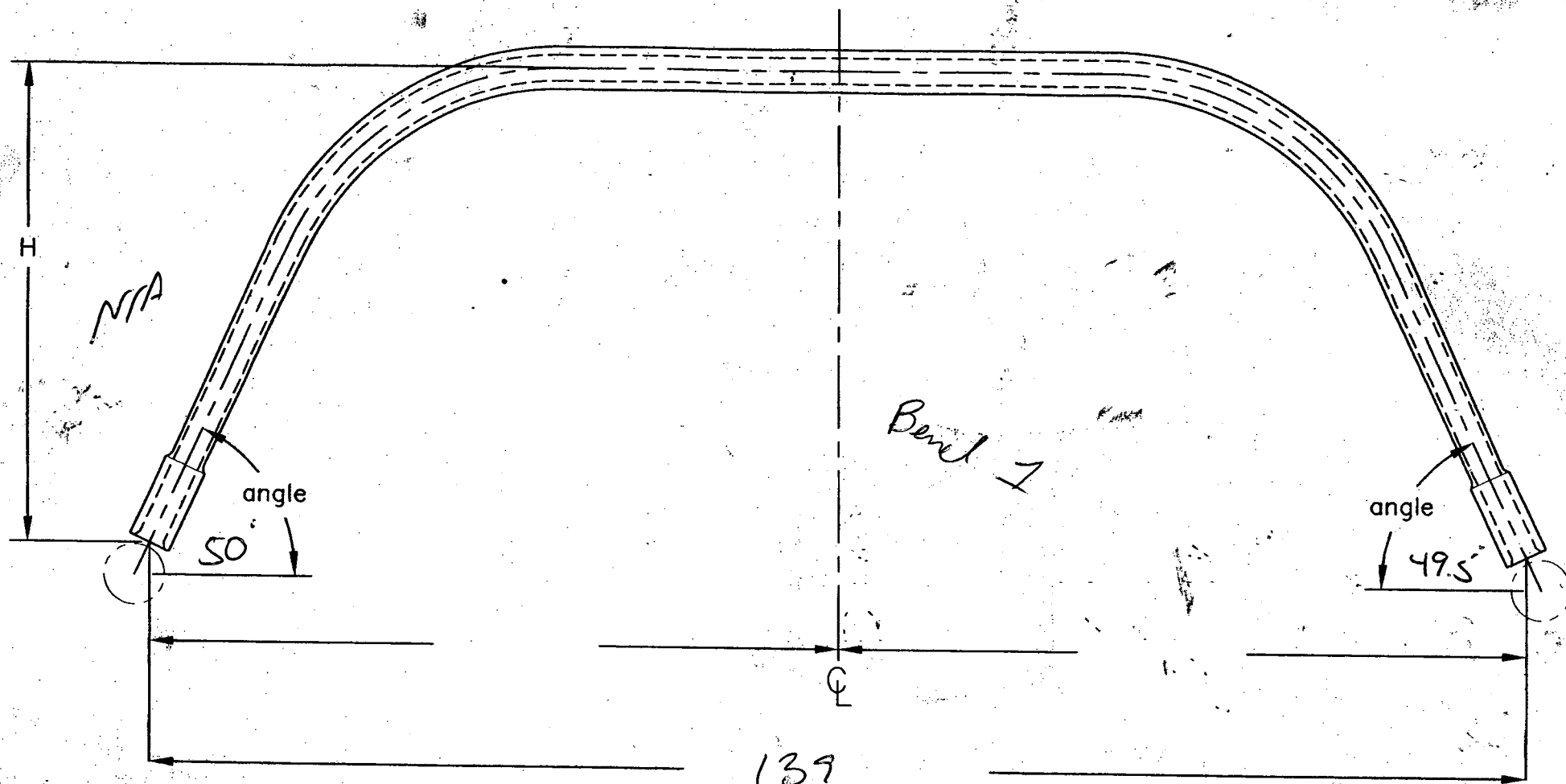
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DATE: 06-10-02

DESCRIPTION: D2890

BATCH NO: B 28491 - C

DRAWING: D2890 Rev. B

H: 50.0"

1/2 SPAN: N/A

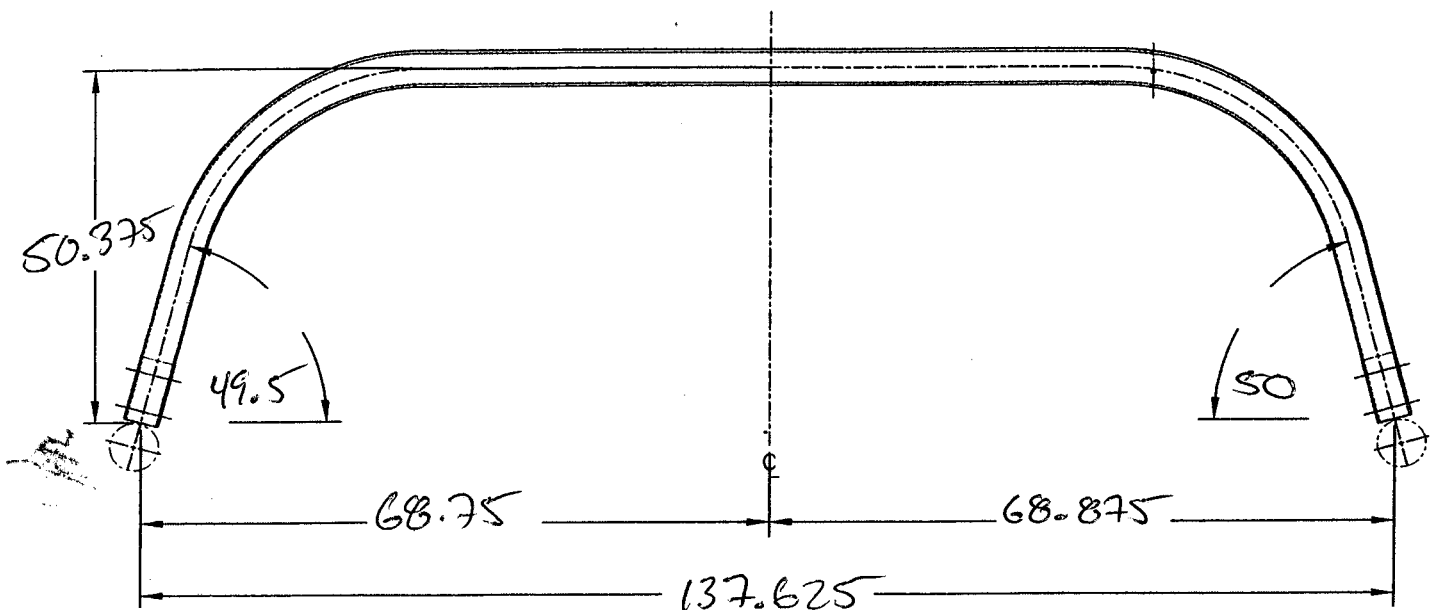
TOTAL SPAN: 138.9

ANGLE: 50⁺²₋₁

[Signature]
06-10-02

DART AEROSPACE LTD		Work Order:	28491-C
Description: Crosstube Aft		Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is Per D205-596-107 B28596.
See E-mail for Dims.
Bend 2

QC15 Inspection	per e-mail for -107. 0705-23
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, May 23, 2007 1:37 AM
To: 'Jason Murdoch'
Cc: 'Linda Lacelle'
Subject: FW:
Attachments: 205 Crosstube.jpg

B28596 is an acceptable deviation as outlined on the attached inspection sheet.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Tuesday, May 22, 2007 11:03 AM
To: 'David Shepherd'
Subject: FW:

Hi there Sir. Here are some dims off of the re-bend tube. We brought the one side in to match, and these measure ments are at .350" over nominal, .250" above the tolerance. Will this fit?

jmurdoch@dartaero.com

Q.C. COORDINATOR

From: Brigitte Golden [mailto:bgolden@dartaero.com]
Sent: Tuesday, May 22, 2007 12:53 PM
To: 'Jason Murdoch'
Subject:

Brigitte Golden
Order Processing
Dart AerospaceLtd.
bgolden@dartaero.com

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.467 / Virus Database: 269.7.6/814 - Release Date: 5/21/2007 2:01 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.467 / Virus Database: 269.7.6/814 - Release Date: 5/21/2007 2:01 PM

5/23/2007